

Work Order ID 51115

August 4, 2009 11:04:39 AM



Page 1

Item ID: D3517-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Strut

Start Date: 8/07/09 Start Qty: 4.00



Cust Item ID:

Required Date: 8/21/09 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: MF

Date: 09-08-04 Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3517	Rev A
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100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3517 Dwg Rev: A Prog Rev: A 112-
Open holes to finish size as per Dwg D3517 113-Deburr if necessary

3

OUT of MAT

IB

9-8-26

(Pha)

(3)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

IB 9-8-26

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

=> 8 or 10/26

(+2)

(+1)

(+1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3517-1 PAR #: 2/A Fault Category: Sm fab NCR: (Yes) No DQA: W Date: 09.08.28
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: W Date: 09.08.28

NCR: <u>51115</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/8/26	#100	Pump qty +1 Part with cut out opening from water jet in the part. R.C machine malfunction	<u>W</u> 09/08/26	Precing goes all the way through the part. Scrap part - no replace.	<u>W</u> 9-8-26	<u>W</u> 09/08/26	<u>W</u> 09/08/26	<u>W</u> 09/08/26

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

MO 09/08/27 (12)

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

Memo M112260
START TIME: 8:15 AM OVEN TEMPERATURE:
8:45 AM FINISH TIME: 320°F

=> 14 09/08/27

2 0

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

OK 09/08/27 (2)

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Page 3

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Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: 509

0.00



Packaging

Memo

0.00

Packaging

160/8/27 @2

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/08/28

09-8-27

Picklist Print

August 4, 2009 11:04:38 AM

Work Order ID: 51115

Parent Item: D3517-1RevA

Parent Item Name: Strut

Comments:

Start Date: 8/07/09

Required Date: 8/21/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.750X06.00 0		Purchased	No				f	5.9100	2.3612			



6061T6 BAR .750 X 6.00



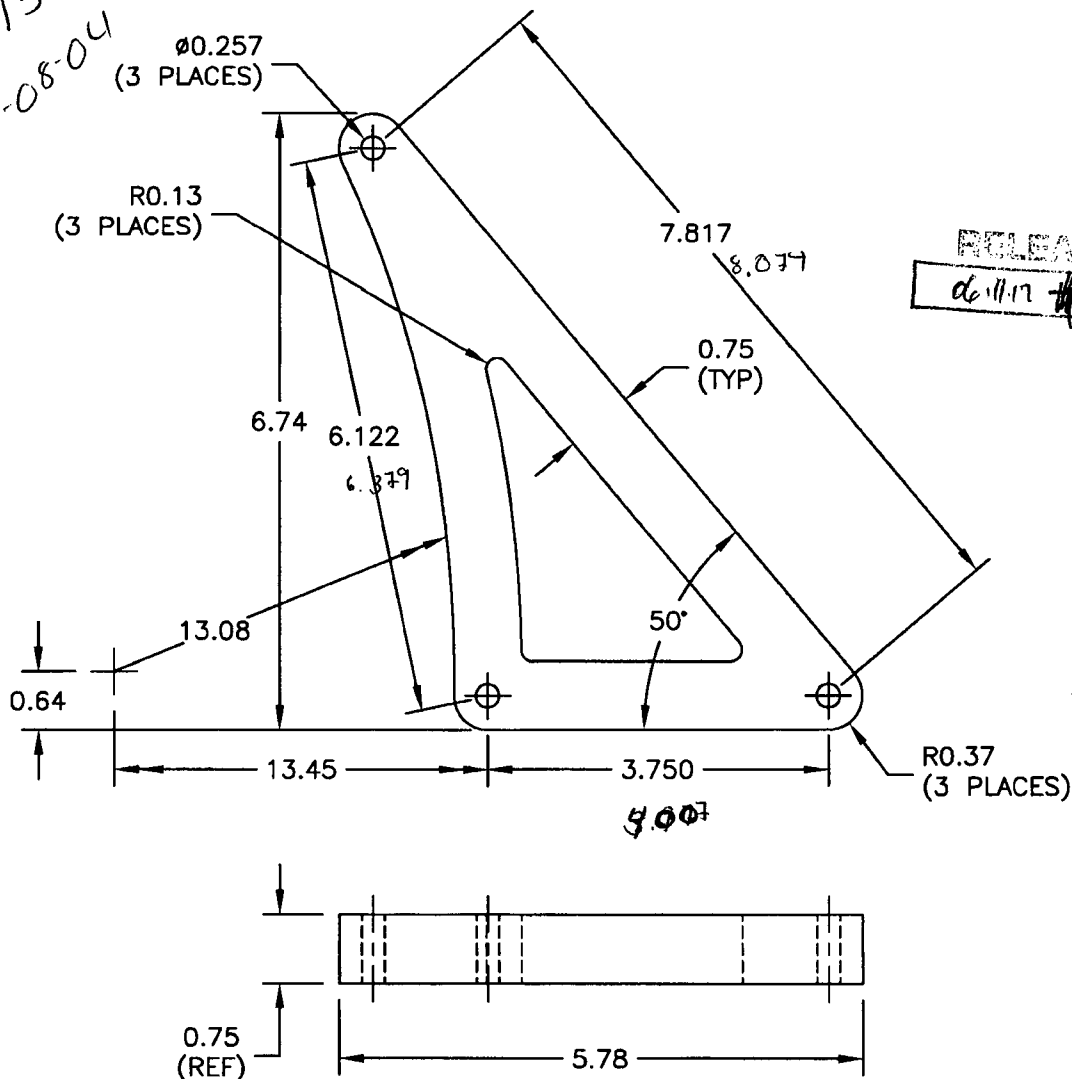
B 9-8-26

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	5.91	
110912	5.91	

110912

DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3517	REV. A SHEET 1 OF 1
DATE 06.06.07		TITLE BASKET (A119) STRUT	SCALE 1:2
A	06.06.07	NEW ISSUE	

**D3517-1 STRUT**

- 1) MATERIAL: M6061-T6 (OR 6061-T651/T6510/T6511/T6512/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF DART MATERIAL SPEC M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) IDENTIFY WITH DART P/N D3517-1 USING FINE POINT PERMANENT INK MARKER
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES 0.005 TO 0.010 MAX

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